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मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6246 (1980): Gauging Members for Plain Plug Gauges GO and NO GO Members (size range above 120 up to and including 250 mm) [PGD 25: Engineering Metrology]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard
SPECIFICATION FOR
GAUGING MEMBERS FOR PLAIN PLUG GAUGES
GO AND NO GO MEMBERS
(SIZE RANGE ABOVE 120 UP TO AND INCLUDING 250 mm)
(First Revision)

1. Scope — Covers requirements for gauging members for plain plug gauges for GO and NO GO members in the size range above 120 up to and including 250 mm. These plain plug gauges may also be used to check the minor diameter of internal threads when made according to IS : 4218 (Parts I to VI) ' ISO metric screw threads '.

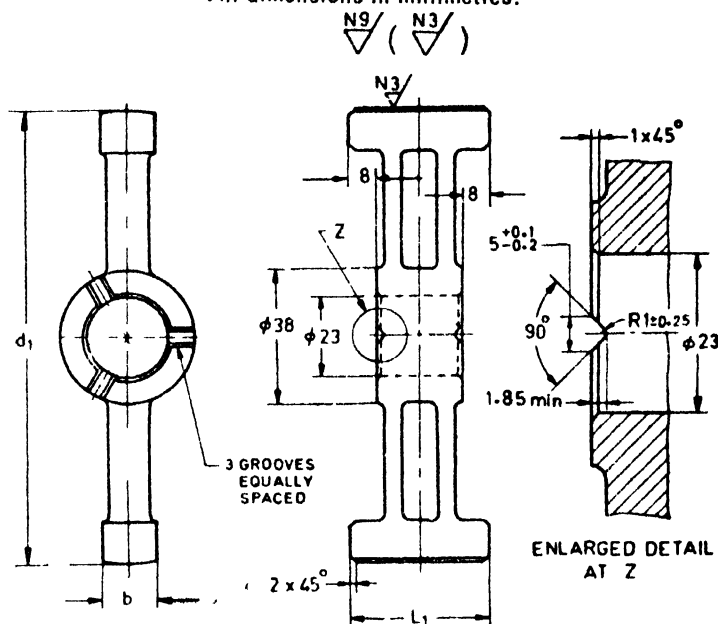
2. Material — Shall be as prescribed in IS : 7018 (Part I)-1973 ' Technical supply conditions for gauges: Part I General '.

3. Dimensions — Dimensions and tolerances for GO and NO GO members for plain plug gauges shall be as specified in Table 1.

TABLE 1 DIMENSIONS FOR GO AND NO GO GAUGING MEMBERS FOR PLAIN PLUG GAUGES (SIZE RANGE ABOVE 120 UP TO AND INCLUDING 250 mm)

(Clause 3)

All dimensions in millimetres.



Nominal Size d_1		b	L_1		Handle* No.
Above	Up to and including		GO	NO GO	
120	140	15	40	28	9 for GO 10 for NO GO
140	160	17	43	30	
160	180	19	46	32	
180	200	21	49	34	
200	225	23	52	36	
225	250	25	55	38	

Note — Chamfer shall be concentric with gauging diameter.

*IS : 5388-1983 ' Hexagon handles for plug gauges plain and threaded (second revision) '.

Adopted 25 August 1980

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IS : 6246-1980

4. Gauging Dimensions — Gauging dimensions for plain plug gauges shall conform to IS : 3455-1971 ' Gauging practice for plain workpieces (*first revision*) ' and IS : 2334-1975 ' Gauging practice for ISO metric screw threads (*first revision*) ' for measuring plain workpieces and minor diameter of internal threads respectively.

5. Designation

5.1 Gauging members for plain plug gauges shall be designated by nominal size of the hole and the tolerance class according to IS : 919 (Part I)-1963 ' Recommendations for limits and fits for engineering: Part I General engineering '.

Example.

A GO or NO GO gauging member for plain plug gauge to check a hole of nominal size 130 mm and tolerance class H8 shall be designated as.

GO Gauging Member 130 H8 IS : 6246

NO GO Gauging Member 130 H8 IS : 6246

5.2 If tolerances other than according to IS : 919 (Part I)-1963 are required, gauging members for plain plug gauges shall be designated by the nominal size of the hole and its limits.

Example:

A GO or NO GO gauging member for plain plug gauge to check a hole of nominal size 130 mm and with a tolerance of $+0.050$ shall be designed as:

GO Gauging Member 130 $^{+0.050}_0$ IS : 6246

NO GO Gauging Member 130 $^{+0.050}_0$ IS : 6246

5.3 Gauging members for checking the minor diameter of internal ISO metric screw threads shall be designated by nominal size of the threads and tolerance class according to IS : 4218-1976 ' ISO metric screw threads '.

Example

GO or NO GO gauging member for plain plug gauge to check the minor diameter of internal ISO metric screw thread size M150 and tolerance class 6H on the minor diameter shall be designated as:

GO Gauging Member M150 6H IS : 6246

NO GO Gauging Member M150 6H IS : 6246

6. General Requirements — Other requirements for gauging members for plain plug gauges not covered in this standard shall conform to IS : 7018 (Part I)-1973

7. Marking — Shall be in conformity with IS : 7018 (Part I)-1973.

7.1 Certification Marking — Details available with the Bureau of Indian Standards.

EXPLANATORY NOTE

This standard was originally published in 1971. At the time of reviewing the specification, the Committee responsible for its preparation felt it necessary to rationalize it on the basis of ISO : 3670-1979 ' Blanks for plug gauges and handles (taper lock and trilock) and ring gauges-design and general dimension '. The main deviations from the earlier standards are :

- i) Gauging members for plain plug gauges GO and NO GO members (size range above 120 up to 250 mm) have been combined to cover the requirements of GO and NO GO members in one specification, IS : 6247-1971 ' Gauging members for plain plug gauges NO GO member (size range 100 to 250 mm) ' stands withdrawn.
- ii) Diameter range has been changed to 120 to 250 mm from the earlier 100 to 250 mm.

- iii) Dimensions other than for measuring surface and also the trilock groove details have been modified.
- iv) Alternate-design given in the earlier version has been deleted.
- v) Surface finish symbols have been modified.

Size range from one up to and including 40 mm and above 40 and up to and including 120 mm have been covered in separate specifications, namely, IS : 6137 ' Gauging members for plain plug gauges GO and NO GO member (size range 1 to 40 mm) ' and IS : 6244 ' Gauging members for plain plug gauges GO and NO GO members (size range 40 to 120 mm) ' respectively.